

5/07

12.62

SPLIT

DART AEROSPACE LTD	Work Order:	22284 A
Description: Battery Lock Body	Part Number:	D3369-1
Dwg: D3369 Rev. A <i>page 2</i>	Qty:	100
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.01.25	100
2	MV	Cut blank: 2.500" x 1.250" x 4.970" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.500x01.250) Identify for D3369-1 Batch: <i>M16 351</i>	<i>SD</i>	05.01.31	<i>96</i> 100
3	MV	Machine D3369-1 as per Folio FA481 and Dwg D3369 Identify as D3369-1	<i>SD</i>	05.01.31	<i>96</i> 100
4	QC2	Inspect parts as they come off the CNC machine	<i>SD</i>	05.01.31	<i>96</i> 100
5	QC8	Second check	<i>[Signature]</i>	05.01.31	<i>96</i> 100
6	MV	Deburr	<i>SD</i>	05.01.31	<i>96</i> 100
7	QC5	Inspect work to Step 6	<i>[Signature]</i>	05.02.09	<i>96</i>
8	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>CPL</i>	05.02.10	<i>96</i>
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	<i>M</i>	05.03.02	<i>96</i>
10	QC3	Inspect Powder Coat	<i>[Signature]</i>	05.03.03	<i>4</i>
11	ST	Identify and Stock	<i>CL</i>	05.03.04	<i>4</i>
12	AC	Cost / part <i>4.90</i>	<i>545</i>	05.03.14	<i>4</i>
13	DC	Close W/O <i>4.90</i> Inspect Level 21	<i>[Signature]</i>	05.03.04	<i>4</i>

Rev	Date	Change	Revised By	Approved
A	05.01.05	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED

TS -003
 74 -002
 75 -007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22284
Description: Battery Lock Body		Part Number:	D3369-1
Inspection Dwg: D3369	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.100	✓			
0.925	+/-0.010	.927	✓			
0.400	+/-0.010	.403	✓			
0.275	+/-0.010	.276	✓			
45°	+/-0.1°	45°	✓			
1.250						
Ø1.125	+0.005/-0.000	1.250	✓			
1.641	+/-0.010	1.649	✓			
2.50	+/-0.030	2.497	✓			
R0.200	+/-0.030	R.2	✓			
4.85	+/-0.030	4.846	✓			
4.350	+/-0.010	4.354	✓			
3.125	+/-0.010	3.019	✓			
Ø0.750	+0.005/-0.000	.750	✓			
0.625	+/-0.010	.627	✓			
0.25	+/-0.030	.25	✓			
1.130	+/-0.030	1.122	✓			
1.49	+/-0.030	1.500	✓			
60°	+/-0.1°	60°	✓			

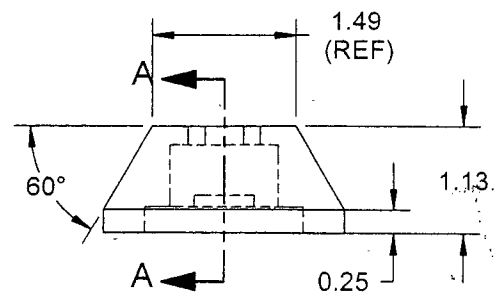
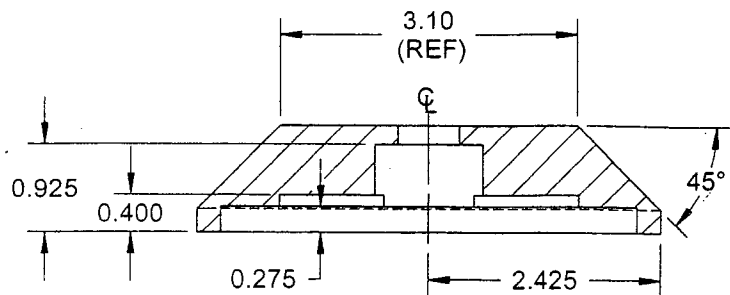
Measured by: SD	Audited by: JML	Prototype Approval: N/A
Date: 05.01.31	Date: 05/02/01	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	

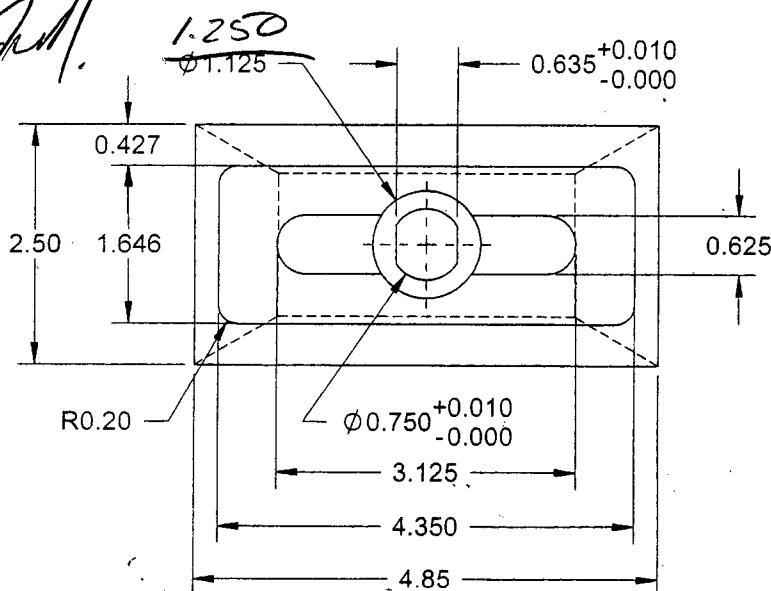
RELEASED
05/05/05

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3369	REV. A SHEET 2 OF 4
DATE 04.12.16	TITLE BATTERY LOCK		SCALE 1:2



SECTION A-A



SHOP COPY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 22284

D3369-1 BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No : 0022284
Project Name : D3369-1
Project For : WK507
Work Order Type : Main
Main WO Number :
House Part Number : D3369-1
Description : Battery Lock Body
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00